

Date: Wednesday, 01/04/2009 3:41:57 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BAR
Job Number : 46781	
Estimate Number : 13483	
P.O. Number :	Part Number : D38065
This Issue : 01/04/2009 S.O. No. :	Drawing Number : D3806 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 01/04/2009 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 46479	Material :
Written By :	Due Date : 08/04/2009 Qty: 2 Um: Each
Checked & Approved By : <u>300 09.04.01</u>	
Comment :	
Est Rev:A 08-07-21 new issue DD verified by:ec	
Est Rev:B 08-09-23 redesign *DD verified by:EC	
Est Rev:C 08-12-05 chg mat. thickness DD verified by:EC	
Est Rev:D 09-03-04 rev.a as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0500X2500	304 BAR .500 x 2.50
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MAT NOT PULLED



Comment: Qty.: 0.9555 f(s)/Unit Total : 1.9110 f(s)
 304 BAR .500 x 2.50
 batch: 111330 FB 9-4-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3806
 Dwg Rev: A
 Prog Rev: A FB 9-4-6

⑥

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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FB 9-4-6

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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300 07.07.06 ⑥

**Comment:** SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-drill holes as per dwg D3806
 2-deburr

EL 9-4-7 ⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 46781

Part Number: D38065

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/04/07 (EG)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/A

EL 9-4-7

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/08 [Signature]

Job Completion



MF
09-04-07

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8 7 6 5 4 3 2 1

D

D

D3806-1 BAR

D3806-5 BAR

C

C

D3806-3 BAR

D3806-7 BAR

B

B

RELEASED
 09-09-03
 per ECN 09-338

SHOP COPY
 RETURN TO
 ENGINEERING
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 WITHOUT NOTICE
 WORK ORDER
 NO. 126181

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	lp	DART AEROSPACE USA, INC.	
DRAWN	lp	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3806	SHEET 1 OF 3
APPROVED	lp	TITLE	SCALE
DE APPR.	lp	BAR	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN	10	DART AEROSPACE USA, INC.	
DRAWN	JS	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV.
MFG. APPR.	JS	D3806	SHEET 2 OF
APPROVED	JS	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
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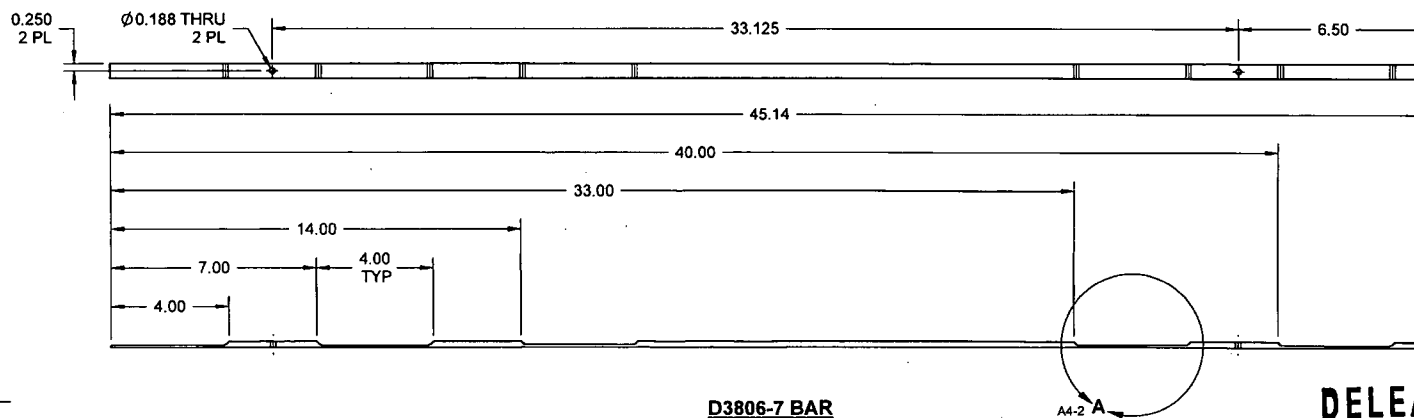
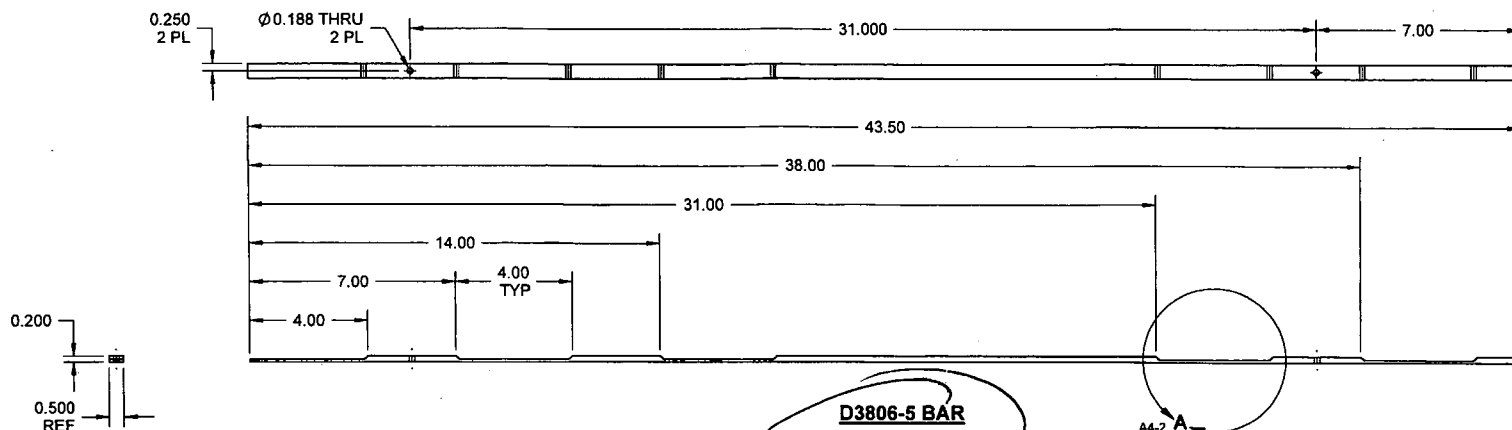
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



RELEASED
09.03.03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.500 THICK
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 0.91 lbs
D3806-7 = 0.97 lbs

DESIGN	47	DART AEROSPACE USA, INC.	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3806	SHEET 3 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BAR	NTS
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WITHOUT NOTICE

8 7 6 5 4 3 2 1

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